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IPLM Group, P.A. P.O. Box 18455 Minneapolis, MN 55418 612-331-7400 telephone 612-331-7401 facsimile

#### Serial No. Attorney Docket No. 53924US010 09/871,223

**PATENT** 

#### FACSIMILE TRANSMITTAL LETTER

TOTAL NO. OF PAGES: 15 Sent to Facsimile No.: 703-872-9306

Examiner Phone No.: 703-308-0716

Commissioner for Patents P.O. Box 1450 Alexandria, VA 22313-1450

In re Application of:	Desmond T. Curran and El	fed I. Williams	
Serial No.:	09/871,223	Examiner:	Aaron J. Lewis
Confirmation No.:	6855	Art Unit:	3761
Filed:	May 31, 2001		
For:		IG COMPONENT ELEMEN AY BE UTILIZED IN RESP	
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In accordance with a telephonic discussion held today with Examiner Lewis, we enclose with this Facsimile Transmittal letter copies of the following documents originally filed on November 17, 2003 and not apparently not yet entered into the prosecution file, together with a copy of the November 17, 2003 USPTO autoreply message received by our office when these documents were first filed:

This Facsimile Transmittal Letter [1 page]

November 17, 2003 Facsimile Transmittal Letter [1 page]

Declaration Under 37 CFR §1.131 of Desmond T. Curran [5 pages] and Attachment A [7 pages]

November 17, 2003 USPTO autoreply message showing receipt of 35 fax pages on November 17, 2003 [1 page]

cc: 703-746-3384

Please charge Deposit Account 50-0549 for any fees under 37 CFR §1.16 and §1.17 that may be required during the pendency of this application. This authorization includes the fee for any extension of time under 37 CFR §1.136(a) that may be necessary. To the extent any such extension should become necessary it is hereby requested.

Respectfully submitted

		Respectionly spondition 7
Registration No. 29,524	Direct Dial 612-331-7412	A-CROUL
Date: November 11, 2004		David R. Cleveland
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		e is being sent to the telephone number shown below, addressed to: 1450, Alexandria, VA 22313-1450, on the below indicated date.
To Facsimile Number 703-872-9306		Signature Rynul H. Dul
Date November 11, 2004		Printed Name Lynelle K. Grube

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# Attorney Docket No. Serial No. 53924US010 09/871,223

**PATENT** 

## FACSIMILE TRANSMITTAL LETTER

TOTAL NO. OF PAGES: 35

Sent to Facsimile No.: <u>703-872-9302</u> Examiner Phone No.: <u>703-308-0716</u>

MS: Non-Fee Amendment Commissioner for Patents P.O. Box 1450

Alexandria, VA 22313-1450

In re Application of:	Desmond T. Curran and El	fed I. Williams	
Serial No.:	09/871,223	Examiner:	Aaron J. Lewis
Confirmation No.:	6855	Art Unit:	3761
Filed:	May 31, 2001		
For:	MANNER OF ATTACHIN MATERIAL SUCH AS M	NG COMPONENT ELEMEN AY BE UTILIZED IN RESP	NTS TO FILTRATION PIRATORY MASKS

We are transmitting the following documents:

Facsimile Transmittal Letter [1 page]

Fee Transmittal for FY 2004 [1 page]

Petition for Extension of Time [1 page]

Amendment [16 pages]

Declaration Under 37 CFR §1.131 of Desmond T. Curran [5 pages] and Attachment A [7 pages]

Declaration Under 37 CFR §1.132 of Lowell E. Christensen [4 pages]

Please charge Deposit Account 50-0549 for any fees under 37 CFR §1.16 and §1.17 that may be required during the pendency of this application. This authorization includes the fee for any extension of time under 37 CFR §1.136(a) that may be necessary. To the extent any such extension should become necessary it is hereby requested.

		Respectfully submitted,
Registration No. 29,524	Direct Dial 612-331-7412	> 1RCOLL
Date: November 1	7, 2003	David R. Cleveland
		and the second second
		rtificate of Facsimile Transmission
Pursuant to 37 CFR 1. MS: Non-Fee Amend	8, I certify that this correspondence Iment, Commissioner for Patents, I	re is being sent to the telephone number shown below, addressed to: P.O. Box 1450, Alexandria, VA 22313-1450, on the below indicated date.
To Facsimile Number	· · · · · · · · · · · · · · · · · · ·	Signature
703-872-9302		Ayrus h. Huse
Date		Printed Name
November 17, 2003		Lynelle K., Grube

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## **3M** Record of Invention (EQMS Cover Page)

#### RESTRICTED

R.I. No. DE 1493	PA2	1539	Page 1 of 7
Originating 3M Unit	102	Patent Lialson	<u> </u>
Engineering, Quality and Manufacturing Sea	rvices	Stephanie A. Fox. 570-1W-03	
Title			
l		•	•
Continuous Motion Valve Atta	achment Mechan		
Investigator (kd first name, middle initial, last name)	)	Investigator (tall first name, middle wited, last name)	
Lee E. Hitzeman		· .	•
3M Emp. No. 032111	•	SM Emp. No.	
Location 98-2-01		Location	
Phone Number 778-5737		Phone Number	
Tech. Notebook No.		Tech. Notebook No.	
Department Name Automation Techno	ologies	Department Name	
Dept. & section No.6801		Dept. & section No.	
Manager's Name Dean A. Shafer		Manager's Name	
Investigator (lub first name, middle initial, lass name)		Investigator (fut first manus, middle tritist last nume)	
Marvin H. Simons	• •	•	in the second
3M Emp. No. 219435	•	3M Emp. No.	
Location 99-1		Location	
Phone Number 778-5439		Phone Number	•
Tech. Notebook No.		Tech. Notebook No.	•
Department Name STP Fabrication	Services	Department Name	
Dept. & section No. 0084-50		Dept. & section No.	
Manager's Name Blaine Haefner		Manager's Name	
Investigator (full first name, middle initial, last name)		Investigator (fut tirst name, middle inhtat, last name)	
Des T. Curran			
3M Emp. No. UK023315		3M Erro. No.	
Location Aycliffe		Location	
Phone Number *8 208-2213	,	Phone Number	
Tech. Notebook No.		Tech. Notebook No.	
Department Name Resident Engines	ering	Department Name	
Dept. & section No. 2297	•	Dept. & section No.	
Managers Name Alan Kellett		Manager's Name	
investigator (tus first name, middle initial, test name)	· • • • • • • • • • • • • • • • • • • •	Investigator (sua first name, middle initial, lest name)	·
Wil Williams	;		
3M Emp. No. UK015049		3M Emp. No.	
Location Gorseinon	•	Location	
Phone Number ₹8 250-2262	ļ	Phone Number	
Tech. Notebook No.		Tech. Natabook No.	
Department Name Process Technolog	y Development	Department Name	
Dept & section No. 2729		Dept. & section No.	
Manager's Name George T. Bates		Manager's Name	•

Instructions: Within EQMS, this cover page should be completed and the information on the investigators can be left blank on the corporate form. This additional information is needed to facilitate processing of the Record of Invention. Investigators should be considered to be those individuals who contributed significantly to the technical content of the subject of this Record of Invention. The attorney will determine inventorship at the time of filing a patent application.

If possible, critical formal drawings should be reduced to 8  $1/2 \times 11$  and included as a page of the Record of Invention. If larger drawings are needed to understand the invention, two sets should be sent with the Record of Invention forms.

Remember timeliness is a factor. Foreign patent applications must be filed prior to the first disclosure of your idea outside 3M. U.S. patent applications must be filed within one year of this disclosure. In the case of a process or process equipment, disclosure includes the first sale of product made using the process or equipment. It frequently takes several months to prepare and submit a patent application. Therefore, it is essential that you submit your RI as soon as possible.

M Record of Invention	RESTRICTE
F.I. No. DE 1493	Page 2 of 7
Originating 3M Unit	Patent Liaison
Automation Technologies/DES	Stephanie Fox. 570-1W-03
Title	
Continuous Motion Valve Attachment Mechanism	
I/TVESTIGATOF (tuli first name, muotie entiet, lass name)	Investigator (tus fing name, mostle entra lust name)
Lee E. Hitzeman	· .
3M Emp. No. 032111	3M Emp. No UK023315
Tech. Ntok. No.  Automation Technologies/DES	Teen. Nibik. No.
UN, OF CAD INAME	Div. or Lab Name Resident Engineering
Investigator (tal first name, chadle write), test name	Investigator (full first name, modile intital, last name)
Marvin H. Simons	Wil Williams
3M Emp. No. 219435	3M Emp. No. UK015049
Tech. Nibk. No.	Tech. Nibk. No.
Div. or Lab Name SIP Fabrication Services	Civ. or Lab Name Process Technology Development
Investigator (vii fire name, micro-micri, last name)	Investigator (let first name, middle instat, last name)
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Tech, Nibk, No.	Tech. Ntbk. No.
Div. or Lab Name	Div. or Lab Name
Information relating to this invention was first written down on or about	
	- (p
Other potentially interested 3M units:	
Was patent/literature search completed?	If so, by whom?
Yes A No.	Who has search results?
Person from whom samples/photos/drawings can be obtained:	
This invantion may relate to government funded research.  Yes	LŽ No
This invention may relate to an outside agreement. Yes	No
invention, and difference(s) and advantage(s) over previous appro- invention. (4) List any other related information such as aublications	e names, jargon, acronyms, etc. unless defined. (2) Describe utility of aches. (3) Provide one or more detalled examples which illustrate the cinemal reports, memoranda, formal drawings, R.I.'s. DO NOT attach in the text of R.I. (5) Identify any other people who were consulted or
<ol> <li>This invention is a high speed Continuous Motion Device the the filter material of a new respirator. It is positioned in-line wit rates in excess of 200 PPM. The attachment forming takes place respirator filter material.</li> </ol>	it forms a mechanical feature that attaches an exhalation valve to ha continuous motion respirator assembly process and operates at after a preassembled valve has been placed in position on the
The process starts with molding a thin wall tube into the base of The tube extends through a hole in the respirator filter material: Motion tooling flares the end of the tube and forces the flare do bottom. The clamping ring attaches the valve to the filter material.	s an assembled valve is positioned for attachment. Continuous on to the base forming and coining a flat clamping ring at the
The filter material is clamped with the valve body on one side of formed attachment holds the valve on the respirator and prevents separate fasteners, adhesives or sealers.	the filter material and the formed clamping ring on the other. The leakage through the seal of the assembly hole without the use of
Described by:	This document has been read and understood by me. Witness:
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## CM Record of Invention (Continuation Page)

RESTRICTED

A.I. No. DE 1493

Page 3 of 7

Tita

Continuous Motion Valve Attachment Mechanism

- 2) This high speed mechanical attachment process and device can be used to attach components of assembly to other components or webs. The device described in this record of invention is for a high speed continuous motion process. This forming process is compatible with intermittent motion assembly as well.
- 3) A need was identified during the development of a new generation of respirators for a high speed process to attach and seal the exhalation valve to the filter material. A special attachment feature was developed by 3M UK and added to the molded valve body. After insertion through the filter material, the feature provides valve material on the backside that can be formed to clamp and seal the valve assembly to the respirator filter material.

The invention of the high speed CONTINUOUS MOTION VALVE ATTACHMENT MECHANISM reshapes the molded feature to clamp and seal the valve to the filter material in a continuously moving web. It is a cold forming process registered to a valve assembly hole through the web. The web is moving at a rate equivalent to 250 PPM.

The high speed CONTINUOUS MOTION VALVE ATTACHMENT MECHANISM is made up of a valve fixture/anvil on a carrier below the filter material web and the forming mechanism on the top. The anvil carriers are attached to an in-line continuous motion conveyor synchronized with the assembly hole through the web. The forming tool developed by 3M U.K. is attached to a rotary continuous motion system that provides tooling perpendicularity during the attachment feature reshaping and clamp forming portion of the cycle. During the forming cycle, the anvil on the carrier is compliant with the forming tooling to maintain proper alignment.

The following sequence of events take place during the High Speed Continuous Motion forming cycle.

#### NOTE:

Assume that a preassembled valve has been loaded onto the anvil carrier. The valve assembly holes have been cut into the filter material web and the anvil carriers are synchronized with the assembly holes in the web. The entire system is running at a continuous motion—rate of 250 CPM. Also assume that the filter web is moving from left to right with the forming tooling system rotating in a counter clockwise direction during the following sequence of events.

The forming sequence begins with the form tooling system contacting the anvil carrier compliancy tab. This controls the registration of the upper and lower systems during the rest of the forming cycle. At this point, the forming tooling system is approximately 47 degrees before bottom centerline ( 6:00 position ). See sketch #1

As the form tooling system continues to rotate toward the bottom centerline position, it follows the art of rotation and moves down in the vertical direction. The spring loaded flare tooling (Nosepiece) engages the inside of the attachment tube on the valve assembly and begins the tube flaring process. This process continues until the nosepiece contacts the fixture anvil which stops it's vertical motion. The fixture anvil now controls the NOSEPIECE in this vertical position throughout the rest of the forming operation.

After the nosepiece contacts the fixture anvil (See sketch #2), the form tooling system outer housing continues to move down vertically which rolls the flared material over. Finally, the bottom face of the form tooling system outer housing forms the flat clamping ring feature that attaches the valve to the filter material. The form tooling system is now at the bottom centerline position and the attachment process is complete. See sketch #4.

The form tooling system continues to rotate until it is in a position approximately 47 degrees after bottom centerline. During this rotation, the process steps reverse to the point where the form tooling system loses contact with the anvil carrier compliancy tab. The tooling returns back to the starting position and the next fixture/anvil carrier presents a valve for the attachment process to repeat the cycle. See sketch #3.

A prototype has been built to verify this concept. A video tape and sample parts are available to show the hardware in operation and results of the process. Future plans are to use this invention on the new Genesis product being developed in the UK.

Form 35751

# **Auto-Reply Facsimile Transmission**



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